

Work Order ID 59206

Friday, May 28, 2010 9:19:11 AM



Page 1

Item ID: D3911-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Installation Stud Assembly, Lower

Start Date: 5/27/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: *H*Date: *5-28*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3911

C

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

EB 10/06/23 (10)

110

0.00



Small Fab

Memo

0.00

Small Fab

1- Assemble D3911-5 to D3911-1 and install rivet as per dwg
Trim rivet to 1.250" Full Length*EB 10/06/23 (10)*

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*80/06/23**(10)*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Identify as per dwg & Stock Location: 507

0.00

Memo

0.00

Packaging

10-6-23 700

140



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

10/06/24

CZ10/06/24

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Picklist Print

Friday, May 28, 2010 9:19:16 AM

Page 1

Work Order ID: 59206



Parent Item: D3911-041



Parent Item Name: Basket Installation Stud Assembly, Lower

Start Date: 5/27/2010

Required Date: 6/4/2010

Comments: IPP RevA: New issue DD verified by:EC
AS PER REV B 10-03-23 JLM VERIFIED BY:DD IPP Rev:C as per dwg
revC 10.04.07 Verified by:JLM

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ D3911-1	Replacement	Mfg/ Manufactured	Bin No	Primary	Last	Route 100	Unit of Each	Qty on 5.0000	Qty per Kit 1	Total 10	Qty	Date	Status
Basket Installation Stud, Lower													

Location

Loc Qty

Loc Code

ST095

5

58786

5

D3911-5

Manufactured

No

100

Each

16.0000

2

20



Basket Stud Plate

Location

Loc Qty

Loc Code

ST095

16

57843

16

MS20615-4M20

Purchased

No

100

Each

73.0000

3

30



RIVET

Location

Loc Qty

Loc Code

ST323

73

113254

7

114324

4

114349

62

1114808

30x



EP 5/10/06/23

359439 (10x)

EP 5/10/06/23

359427 (14x)

EP 5/10/06/23

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

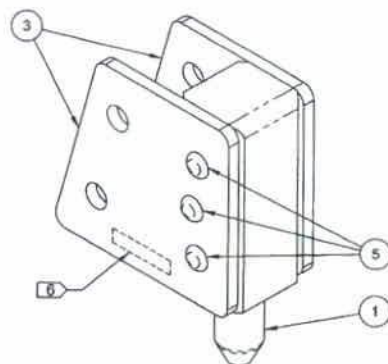
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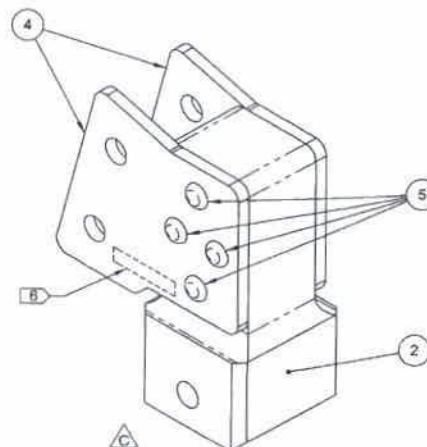
ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D3911-041	BASKET INSTL STUD ASSY (LOWER)
		X	D3911-043	AFT EYEBOLT RECEIVER ASSY
1	1		D3911-1	BASKET INSTL STUD (LOWER)
2		1	D3911-3	AFT EYEBOLT RECEIVER
3	2		D3911-5	BASKET STUD PLATE
4		2	D3911-7	BASKET PLATE-EYEBOLT RECEIVER
5	3	4	MS20615-4M20	RIVET



D3911-041 BASKET INSTL STUD ASSY (LOWER)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3911-04X USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 0.63 lbs
-043: 0.99 lbs



D3911-043 AFT EYEBOLT RECEIVER ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59204
PS 10-5-28

RELEASED
2010-04-16

C	BOM: QTY (2): D4087-1 & MS21209-C810 REMOVED FROM -043 ASSY. WEIGHT UPDATED. D3911-3 REDESIGNED. D3911-043 & D3911-3 DETAIL UPDATED. MTL SPEC ADDED TO NOTES (SHT 2). DIM 0.375 WAS 0.400 (C3-3).	JPH	10.04.06
B	DIAMETER (B3-2) AND DIM ADDED (B2-2) & (C3-2)	JPH	10.03.16
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH		
DRAWN	JPH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.04.06		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3911** REV. C
TITLE **AFT HARDPOINT, BASKET** SCALE NTS

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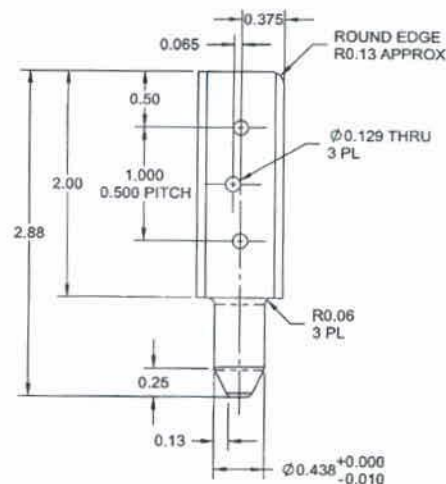
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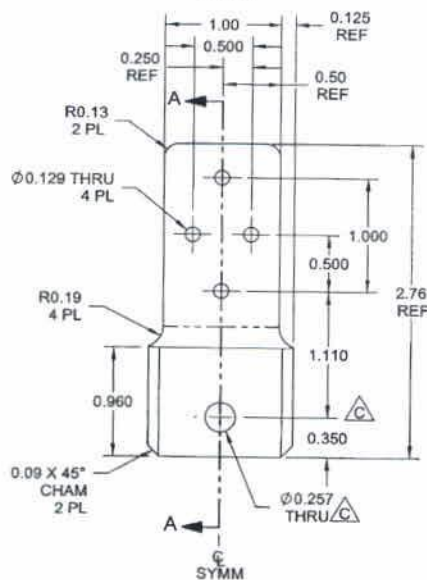
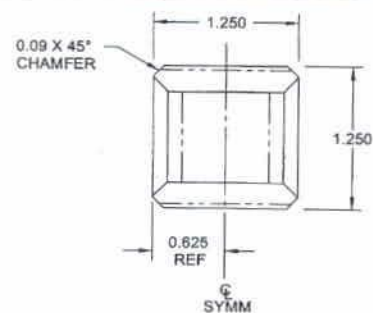
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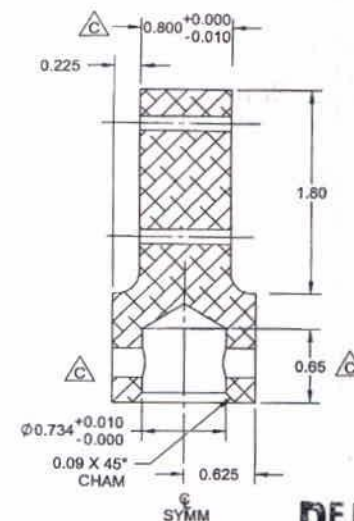
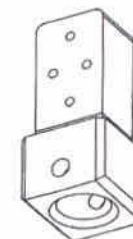
NOTE: Date & initial all entries



D3911-1 BASKET INSTL STUD (LOWER)



D3911-3 AFT EYEBOLT RECEIVER



RELEASED
2010-04-14

SECTION A-A

NOTES:

- NOTES:
- 1) MATERIAL -1: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303R OR M304R
-3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT -1: 0.36 lbs
-3: 0.73 lbs

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3911 TITLE AFT HARDPOINT, BASKET COPYRIGHT © 2015 BY DART AEROSPACE LTD <small>ALL INVENTIONS & RIGHTS ARE RESERVED. NO PART OF THIS DOCUMENTATION MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.</small>	REV. 0
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MFG. APPR.	<i>[Signature]</i>		NITS
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE 10.04.06			

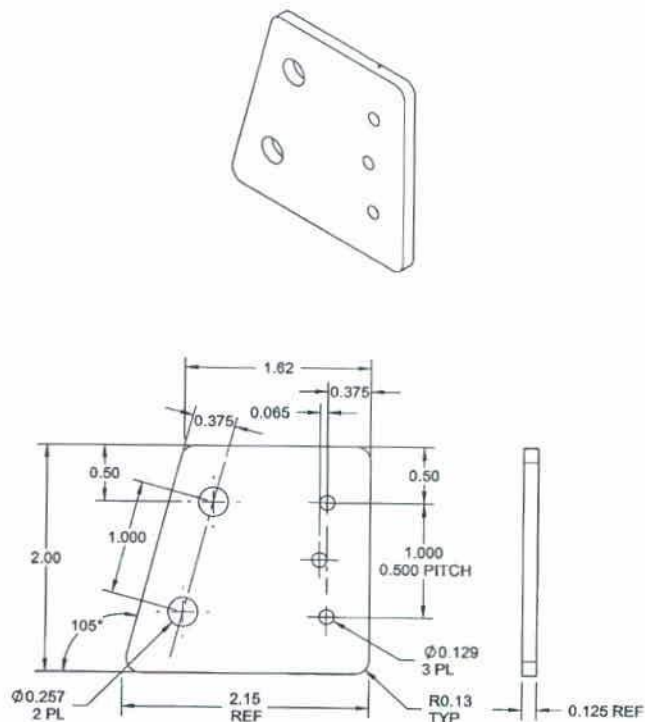
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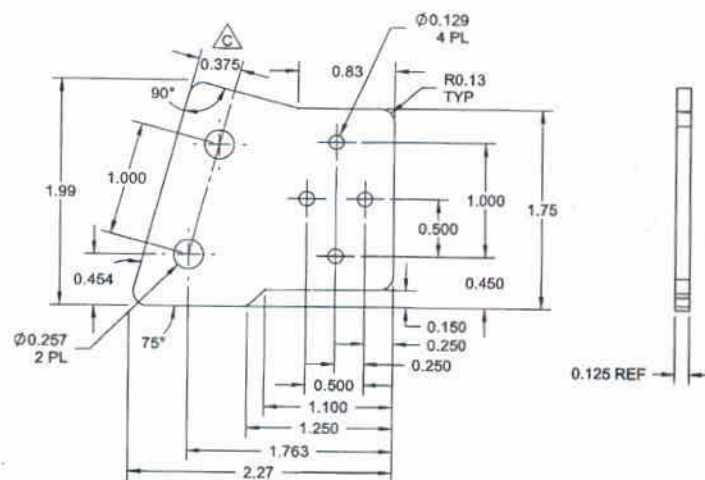


D3911-5 BASKET STUD PLATE

NOTES:

- 1) MATERIAL -5 & -7: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240
PER DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT -5: 0.13 lbs
-7: 0.13 lbs

w/o 59206



D3911-7 BASKET PLATE-EYEBOLT RECEIVER

RELEASED
2010-04-14

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APPROVED		TITLE	SCALE
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